Work Orde	er ID 109543				Page 1								
Revision ID:	D3161-7 Hinge 14.0"		,	Accept	*	1 900	<u>040</u>	* *N	S1* S2*				
Start Date: Required Date: Reference:		t Qty: 2.00 d Qty: 2.00	*2* *2*			Cust Item l	ID:						
Approvals: Process Plan: MLJ QC:						Date:]	Run Star Sto	17	R1* 4 R2*	4
Sequence ID/ Work Center II	Oper O Desci	ration ription		Set Up/ Run Hoi	urs	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	-
Draw Nbr	Revision I	Nbr											
D3161	Rev A2												
*1 \\ \Cappa \\ \text{Small Fab} \\ Small Fab	. Small	Memo	ge makes (5) D3161-7 parts	0.00 0.00 at 14" longCut to) length as per	Dwg		•	Lx.			B/u/a	36 69-89
110 *110* QC Quality Control	QC5-	Inspect part comp	leteness to step on W/O	0.00 P	DAS 27 9-89				<u> </u>			- .	
120 *120* Packaging	Identi	fy as per dwg & St Memo	tock Location: <u>570</u> 3/	0.00					_2x	DAS - 28 - 9-89	<u> 13-11</u>	-26	

Packaging

DQA:	Date:								_				TRAGE
0.4.01			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	14/	ork Order ur	odata only	AEROSPACE
QA Closed:		ŀ	Date:				_			VV	ork Order up	date only	<u> </u>
Work Order:			DISPOSITION			AGAINS							
Work or at	- Graci.			_	Rework			Skid-tube Crosstube	e]	Water Jet	Engineering	
Part N	۷o.					Scrap			Machining Small Fal	-	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therr	noforming Finishin	g	Rec/Sto	re/Packaging	Other
NCR I	No.		<u>-</u> .			Suspected Unapproved		Large Fab Composite	e]	Supplier		
[°] Root					Desc	ription of work order update	Н	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	•	ief Eng			Date	Verification	QC Inspector
Design					-				·				
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material				ļ									
Operator				İ									
Offset/Setup		ı]									
Process				1							·		
Supplier				ŀ									
Training													
Transport												:	
Unapproved													
							FA	ULT CA	TEGORY				
Landi	ng (Gear			_	General	_	1		_	7	_	-
	<u> </u>	Bending				Bend		1	Program	<u> </u>	Outside Dim	}	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain		-	Over/Under		Set-up
	<u> </u>	Cracks			<u> </u>	Broken/Damage/Defect	L	Hardwa		-	Part Incorre	-	Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave		Burrs	<u></u>	- i	ion Incomplete/Unqualified	<u> </u>	Part Lost/M	issing	Weld
	Cuffs				-	Contamination	_	4	tions Incomplete/Unclear	\vdash	Part Moved	L	Wrong Stock Pulled
	Crushing			<u> </u>	Countersink	_	4	gned/off center	\vdash	Positioned \	_	7	
	Heat Treat			Cut Too Short	L	Mislab		L	Power Loss/	Surge	Other		
	Inspection Strip in Tube			\vdash	Drawing	<u></u>	Misrea						
1	<u> </u>	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set					
	<u> </u>	Turning S			_	Finish	\vdash	4	Calibration				
	Wave/Twist in Tube			e		Fit/Function	L_	Out of Sequence					

Work Order	ID	109543
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109543

Page 2

November-21-13 2:34:17 PM

Item ID:

D3161-7

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Required Date: 11/21/13

Hinge 14.0"

11/21/13

Start Oty: 2.00 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Stop

Sequence ID/ Work Center ID Operation Description

QC:____

Date:

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number Stamp

Insp.

130

130

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

3m 13/11/28.

DQA:	\: Date:														
						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
QA Closed: Date:								_							
Work Order:					DISPOSITION	l		AGAINST							
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Part N	lo.					Scrap	ı		Machining Small Fab	-	Pro	d. Eng. Coor.	Quality		
	-				_	Use-as-is			noforming Finishing		4	re/Packaging	Other		
NCR N	۱o. ₋				_	Suspected Unapproved			Large Fab Composite]	Supplier			
Root		:	Descrip			iption of work order update	ı	nitial	Action		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
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Supplier															
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Landi		•				General		1:-/	D		Outside Dim	: Г	Pressure/Forced		
	H	Bending			-	Bend	\vdash	1	Program	-	Over/Under	<u> </u>	-		
	_	Centre No	ot Concer	ntric	-	BOM/Route	\vdash	Grain		\vdash	Part Incorre	—	Set-up Temperature/Cure		
		Cracks	alı/Dinnla	/\4/=\-=	-	Broken/Damage/Defect		Hardwa	are tion Incomplete/Unqualified	\vdash	Part Lost/M	<u> </u>	Weld		
		Crimp/Kir	пк/кірріе	ywave	⊢	Burrs	\vdash	1	• • •	-	Part Moved	-	Wrong Stock Pulled		
	_	Crushing			-	Contamination Countersink	\vdash	-1	tions Incomplete/Unclear gned/off center	\vdash	Positioned V	L Vrong	vviong stock runeu		
	Crushing				Cut Too Short	\vdash	Mislab	=	\vdash	Power Loss/		Other			
				Drawing	-	Misrea		_	Ti owei coss/	Juige [Jones	_			
	Inspection Strip in Tube Marks/Chatter			\vdash	Drill Holes	\vdash	Off-set						_		
ļ		Turning S			\vdash	Finish		4	Calibration					_	
	\vdash	-			\vdash	Fit/Function	-	4	Sequence					_	
L	Wave/Twist in Tube					I 19 1 direction		10000	Jegaenice						

Work Order ID:

109543

Parent Item:

D3161-7

Parent Item Name: Hinge 14.0"

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP A04.08.24New IssueKJ/JLM

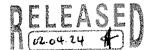
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	DA:
MS20257-3-7200 PIANO HINGE		Purchased	No			100	f	71.7237	1.2	2.4	ן גו	1/26		9-8
t.				Location		Loc Qty	<u>Lo</u>	c Code						
				ST209a		71.7236838								
				12	23960	2.2447368								
				m	126275	0.509842								
				m	127172 🖚	32.969105			2.	4_				
•				m	127393	36								

DQA:		Date:							_							
			. .			WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
QA Closed:			Date:		÷						wo	rk Order up	date only			
Work Order:			DISPOSITION													
Work Orac	-				_	Rework			Skid-tube	Crosstube			Water Jet		Engineering	
Part N	lo.					Scrap			Machining	Small Fab		Prod. Eng. Coor.			Quality	
	•					Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other	
NCR N	۱o.				·	Suspected Unapproved		Large Fab Composite				Supplier				
Root		:	Ì		Desc	ription of work order update		nitial	Act	ion	\exists	Sign &				
Cause		Date	Step	Qty		or non-conformance	l	ief Eng	Descr	ription		Date	Verification		QC Inspector	
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	<u> </u>	Bending	_		<u> </u>	Bend	_	1 .	Program			Outside Dim	-	_	Pressure/Forced	
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	<u> </u>	Cracks	1 (5)		_	Broken/Damage/Defect	<u> </u>	Hardwa		11 <i>4</i> 11	-	Part Incorre			Temperature/Cure	
	Crimp/Kink/Ripple/Wave			-	Burrs	\vdash	-1	tion Incomplete/Ur	· .	_	Part Lost/Mi	ssing	\dashv	Weld		
	Cuffs			-	Contamination	\vdash	4	tions Incomplete/l	Jnciear	-	Part Moved	L ''		Wrong Stock Pulled		
	Crushing			Countersink		Mislab	gned/off center	}	-	Positioned V Power Loss/			Other			
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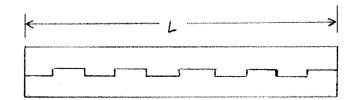




DESIG	A A	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHEC	KED KED	APPROVID	DRAWING NO. D3161	REV. A
DATE	02.04	. 24	TITLE HINGE	SCALE NTS
A	02	.04.24	NEW ISUE	
Ai	H to	94.02.27	ADDED \$3161-5	
A 2	P.A.	04.06 30	100 03/61-7 8 03/61-9	and the second s



PIN	LENGTH 'L'	DESCRIPTION
D3161-1	13.5"	HINGE (REPLACES MS 20257-3-13.5 ON DZ183)
D3161-3	15.0"	HINGE (REPLACES MS 20257-3-150 ON D2950-041)
D3161-5	9.9"	HINGE
03161-7	14,0"	HINGE
03161-9	17.6"	HINGE



NOTES:

(1) MAKE FROM MS20257-3-7200 HINGE

13-11-22